



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-591-312
Job Sheet 186599



Part No: D350-591-312

Job Qty: 5 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/18/18

Job Tracking No: AIRBUS

Due Date: 1/25/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	1/25/19	0.00	0.00	0.00	Start Up Large Fab-4		SLU
110	Large Fab	5 pcs	1/25/19	0.00	5.00		Large Fab 2		SLU
120	QC	5 pcs	1/25/19	0.00	0.00		QC9		CPC
130	QC	5 pcs	1/25/19	0.00	0.00		QC5		CPC
140	HandFinish	5 pcs	1/25/19	0.00	0.94		HandFinish1		D.R. 19/01/16
150	QC	5 pcs	1/25/19	0.00	0.00		QC7-2		CPC
180	Large Fab	5 pcs	1/25/19	0.00	5.00		Large Fab 2		SLU
190	QC	5 pcs	1/25/19	0.00	0.00		QC10		CPC
200	QC	5 pcs	1/25/19	0.00	0.00		QC5		CPC
210	HandFinish	5 pcs	1/25/19	0.00	0.94		HandFinish1		D.R. 19/01/18
220	Powdercoat	5 pcs	1/25/19	0.00	1.49		Powdercoat1		SLU 19-01-21
230	HandFinish	5 pcs	1/25/19	0.00	0.94		HandFinish3		SLU 19-01-22
240	QC	5 pcs	1/25/19	0.00	0.00		QC3		38
250	Packaging	5 pcs	1/25/19	0.00	0.00		Packaging1-3		DAS 19-01-23
260	QC	5 pcs	1/25/19	0.00	0.00		QC4		DAS 19-01-23
270	Packaging	5 pcs	1/25/19	0.00	0.00		Packaging3-1		9-89-88 JAN 23 2019
275	DC	5 pcs	1/25/19	0.00	0.00		DC		DAS 19-01-23
280	QC21-FG	5 Ea	1/25/19	0.00	0.00		QC21		DAS 19-01-23

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Descriptions: Dwg D3272 A/R Aluminum Rod 138872 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 1:50 OVEN TEMPERATURE: 320 FINISH TIME: 2:20

270 - Identify and pack for shipping as per PPPD350-591-312 Location FG109

275 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

wing walk M138963

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	10 Ea (2 ea)	90-Start up Operation	8125543
D3219-1	Plate	10 Ea (2 ea)	90-Start up Operation	5133550
D3272-1	Step	5 Ea (1 ea)	90-Start up Operation	5141646

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

65-041	Step Leg Assembly	5 Ea (1 ea)	180-Large Fab
6-1	Spacer	10 Ea (2 ea)	180-Large Fab
MS20600-AD4W4	Rivet	80 Ea (16 ea)	180-Large Fab
AN3-35A	Bolt	10 Ea (2 ea)	250-Packaging
AN4-13A	Bolt	40 Ea (8 ea)	250-Packaging
AN5-36A	Bolt	10 Ea (2 ea)	250-Packaging
D2230-3	Mounting Lug	20 Ea (4 ea)	250-Packaging
D2618	Bushing	10 Ea (2 ea)	250-Packaging
D2856-400-720	Abrasion Strip 4" X 7.20"	10 Ea (2 ea)	250-Packaging
D3235-1	Mounting Lug	10 Ea (2 ea)	250-Packaging
D3278-041	Support Assembly	5 Ea (1 ea)	250-Packaging
MS21042L3	Nut	10 Ea (2 ea)	250-Packaging
MS21042L4	Nut	40 Ea (8 ea)	250-Packaging
MS21042L5	Nut	10 Ea (2 ea)	250-Packaging
NAS1149D0363J	Washer	20 Ea (4 ea)	250-Packaging
NAS1149D0463J	Washer	80 Ea (16 ea)	250-Packaging
NAS1149D0563J	Washer	20 Ea (4 ea)	250-Packaging

5144707 / 5132616
3128757
5117999

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	10	260	0
	D3219-1	10	219	0
	D3272-1	5	1	0
180-Large Fab	D3065-041	5	21	0
	D3066-1	10	350	0
	MS20600-AD4W4	80	2,558	0
250-Packaging	AN3-35A	10	253	0
	AN4-13A	40	950	0
	AN5-36A	10	116	0
	D2230-3	20	68	0
	D2618	10	169	0
	D2856-400-720	10	186	0
	D3235-1	10	109	0
	D3278-041	5	43	0
	MS21042L3	10	1,721	0
	MS21042L4	40	1,882	0
	MS21042L5	10	423	0
	NAS1149D0363J	20	2,068	0
	NAS1149D0463J	80	2,662	0
	NAS1149D0563J	20	1,308	0

Part Specifications

Specifications could not be found.

Plex 11/19/18 8:38 AM Dart.lajeunesse.marie

7401

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																										
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DART Aerospace Ltd. 1270 Aberdeen Street Hawkebury, ON K6A 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S143680 Part: D350-591-312 Job No: 186599 Serial No/Batch: S143680 Revision: Inspector: Exp Date: Instructions: TC STC SH92-6 Issue 1d, FAA STC SH967NE 04/12/21, BRAZIL 1			Completed By																																											
			Lead hand / Supervisor Approval Verification																																											
			QC / QA Coordinator Approval																																											
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D350-591-312
Job Sheet 186599



Part No: D350-591-312

Job Qty: 5 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/18/18

Job Tracking No: AIRBUS

Due Date: 1/25/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea		1/25/19	0.00	0.00	Start Up Large Fab-4		
110	Large Fab	5 pcs		1/25/19	0.00	5.00	Large Fab 2		
120	QC	5 pcs		1/25/19	0.00	0.00	QC9		
130	QC	5 pcs		1/25/19	0.00	0.00	QC5		
140	HandFinish	5 pcs		1/25/19	0.00	0.94	HandFinish1		
150	QC	5 pcs		1/25/19	0.00	0.00	QC7-2		
180	Large Fab	5 pcs		1/25/19	0.00	5.00	Large Fab 2		
190	QC	5 pcs		1/25/19	0.00	0.00	QC10		
200	QC	5 pcs		1/25/19	0.00	0.00	QC5		
210	HandFinish	5 pcs		1/25/19	0.00	0.94	HandFinish1		
220	Powdercoat	5 pcs		1/25/19	0.00	1.49	Powdercoat1		
230	HandFinish	5 pcs		1/25/19	0.00	0.94	HandFinish3		
240	QC	5 pcs		1/25/19	0.00	0.00	QC3		
250	Packaging	5 pcs		1/25/19	0.00	0.00	Packaging1-3		JAN 10 2019
260	QC	5 pcs		1/25/19	0.00	0.00	QC4		
270	Packaging	5 pcs		1/25/19	0.00	0.00	Packaging3-1		
275	DC	5 pcs		1/25/19	0.00	0.00	DC		
280	QC21-FG	5 Ea		1/25/19	0.00	0.00	QC21		

Part Op **110** - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod _____ 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

270 - Identify and pack for shipping as per PPPD350-591-312 Location FG109

275 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

Job 186599

007401

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	10 Ea (2 ea)	90-Start up Operation	
D3219-1	Plate	10 pcs (2 ea)	90-Start up Operation	
D3272-1	Step	5 Ea (1 ea)	90-Start up Operation	
D3065-041	Step Leg Assembly	5 pcs (1 ea)	180-Large Fab	
D3066-1	Spacer	10 pcs (2 ea)	180-Large Fab	
MS20600-AD4W4	Rivet	80 Ea (16 ea)	180-Large Fab	
AN3-35A	Bolt	10 Ea (2 ea)	250-Packaging	5101329
AN4-13A	Bolt	40 Ea (8 ea)	250-Packaging	5115326
AN5-36A	Bolt	10 Ea (2 ea)	250-Packaging	5099504
D2230-3	Mounting Lug	20 Ea (4 ea)	250-Packaging	5137811
D2618	Bushing	10 Ea (2 ea)	250-Packaging	5137950x2 5143159x8
D2856-400-720	Abrasion Strip 4" X 7.20"	10 pcs (2 ea)	250-Packaging	5121768
D3235-1	Mounting Lug	10 pcs (2 ea)	250-Packaging	5113205
D3278-041	Support Assembly	5 pcs (1 ea)	250-Packaging	5136112
MS21042L3	Nut	10 Ea (2 ea)	250-Packaging	5132364
MS21042L4	Nut	40 Ea (8 ea)	250-Packaging	5129970
MS21042L5	Nut	10 Ea (2 ea)	250-Packaging	5093592
NAS1149D0363J	Washer	20 Ea (4 ea)	250-Packaging	5107782
NAS1149D0463J	Washer	80 Ea (16 ea)	250-Packaging	5129985
NAS1149D0563J	Washer	20 Ea (4 ea)	250-Packaging	5058053

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	10	174	0
	D3219-1	10	223	0
	D3272-1	5	5	0
180-Large Fab	D3065-041	5	13	0
	D3066-1	10	253	0
	MS20600-AD4W4	80	4,832	0
250-Packaging	AN3-35A	10	151	0
	AN4-13A	40	480	0
	AN5-36A	10	116	0
	D2230-3	20	114	0
	D2618	10	117	0
	D2856-400-720	10	182	0
	D3235-1	10	63	0
	D3278-041	5	46	0
	MS21042L3	10	2,479	0
	MS21042L4	40	2,027	0
	MS21042L5	10	319	0
	NAS1149D0363J	20	1,855	0
	NAS1149D0463J	80	3,022	0
	NAS1149D0563J	20	1,187	0

Part Specifications

Specifications could not be found.

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Heli-Access-Step™</i> , Short Step – High Skid, LH
	X					D350-591-214	<i>Heli-Access-Step™</i> , Short Step – High Skid, RH
		X				D350-591-215	<i>Heli-Access-Step™</i> , Short Step – Low Skid, LH
			X			D350-591-216	<i>Heli-Access-Step™</i> , Short Step – Low Skid, RH
				X		D350-591-311	<i>Heli-Access-Step™</i> , Long Step – High Skid, LH
					X	D350-591-312	<i>Heli-Access-Step™</i> , Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

Change Record

PAGE 1 OF 2

Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

[illegible]